

Work Order ID 62228

Wednesday, September 22, 2010 3:16:05 PM

Page 1

Item ID: D3407-041

Accept

Revision ID:

Item Name: Tow Ring

Start Date: 9/22/2010 Start Qty: 10.00

Required Date: 9/29/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date: 10-9-23 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3407

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004
A/R TIG174 ROD Batch: 4101972

110

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



SY 10/11/04 10

CP 10-10-04

410

8/10/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62228

Wednesday, September 22, 2010 3:16:06 PM



Page 2

Item ID: D3407-041

Accept



Setup Start



Revision ID:

Item Name: Tow Ring

Stop



Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

11/5291

Memo

0.00

Powder Coating

**Mask Threaded Section

START TIME: *10:30*

OVEN TEMPERATURE: *400°*

FINISH TIME: *11:00*

10 BR 10-11-11

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

el

10 11/12

Memo

0.00

10

150



Packaging

Packaging

Identify as per dwg & Stock Location: *464*

0.00

Memo

0.00

10/14/12 (10)

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/12 *[Signature]*R/10-11-12
(10)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 1

[illegible]

Required Date: 9/29/2010

Required Qty: 10.00

Comments: IPP Rev:A 05.10.14 New issue KJ/EC
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-1		Manufactured	No			100	Each	11.0000	1	10			
									<i>B62726 10x NY 10/11/03</i>				
Stem													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			11						
					59618		11						
D3407-5		Manufactured	No			100	Each	24.0000	1	10			
									<i>NY 10/11/03</i>				
Ring													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			24						
					59912		10						
					61688		14						
								<i>62641</i>	<i>Ex 5x</i>				
									<i>SA 5x</i>				

W/O:		WORK ORDER CHANGES					
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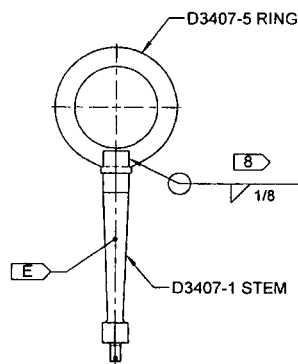
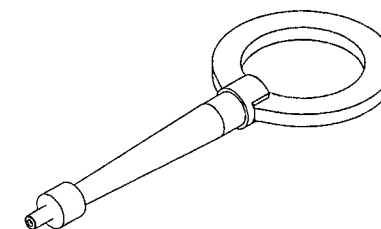
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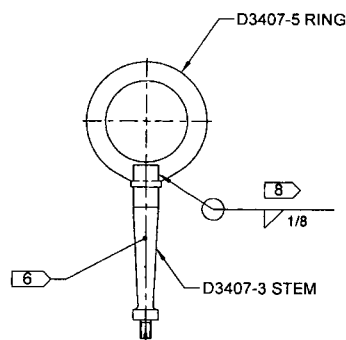
NOTE: Date & initial all entries

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

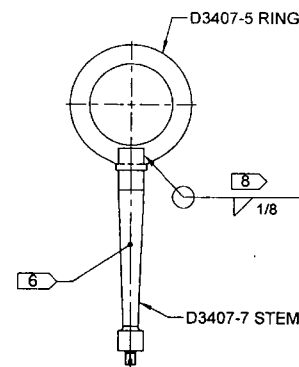
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMIT TO IDENT
NO. 62228
PS 10-9-23



D3407-041 TOW RING



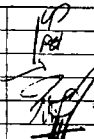
D3407-043 TOW RING



D3407-045 TOW RING

RELEASED

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN		DRAWING NO.	REV.
CHECKED		D3407	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		TOW RING	NTS
DE APPR.			
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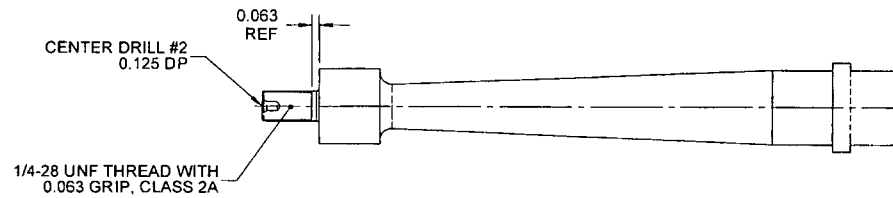
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

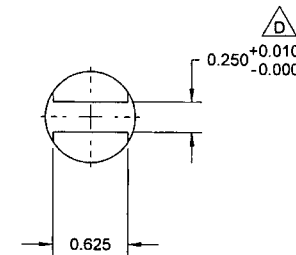
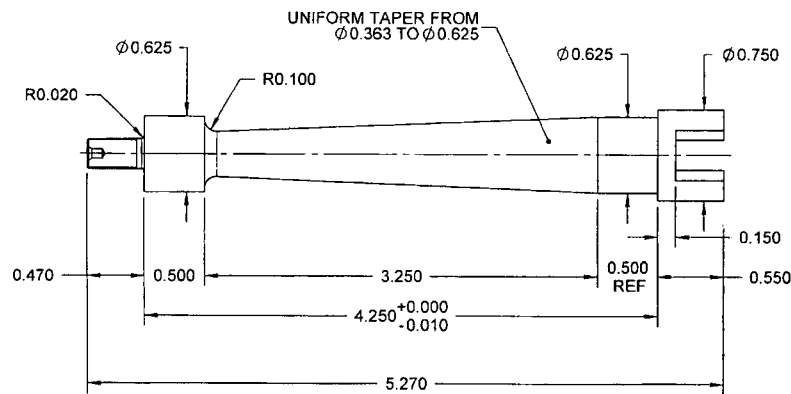
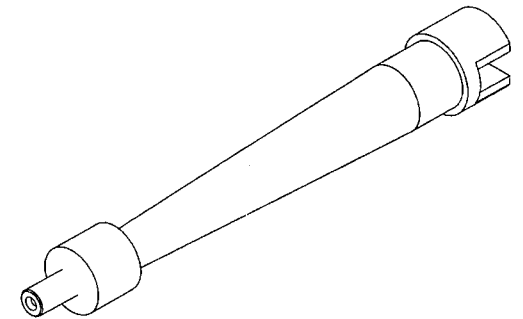
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







alo 62225



D3407-1 STEM

RELEASED
08-07-23

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
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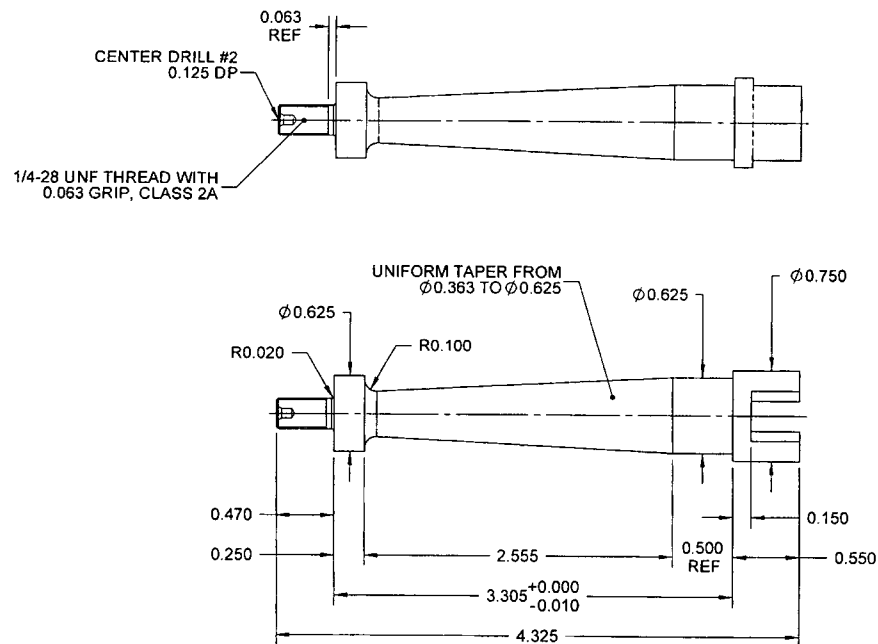
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

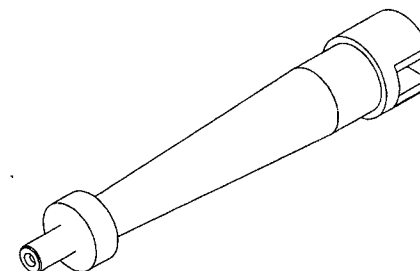
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3407-3 STEM

cto 62225



- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

RELEASED

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CHECKED	<i>JP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JP</i>	D3407	SHEET 3 OF 5
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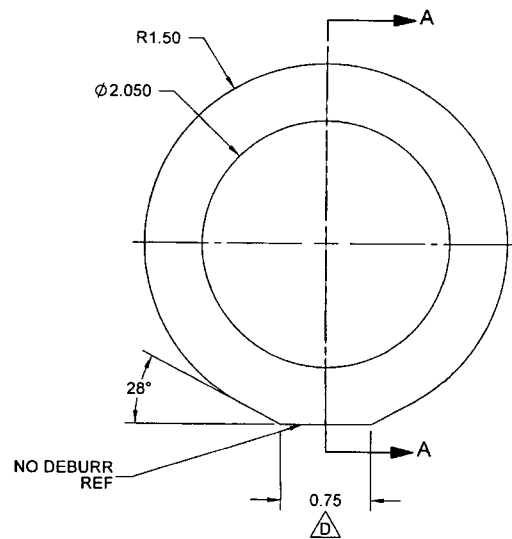
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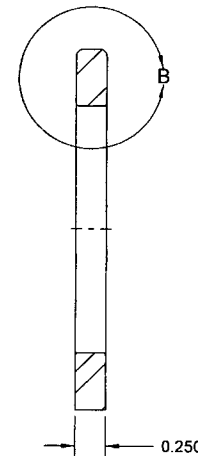
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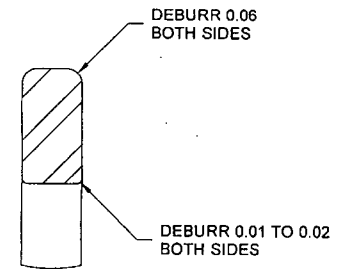
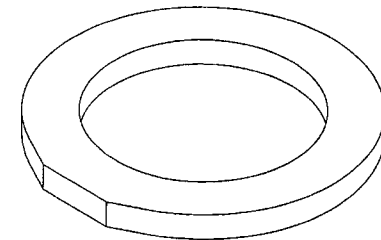
ULO 62228



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-07-23

- NOTES:**
 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.27 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3407	SHEET 4 OF 5
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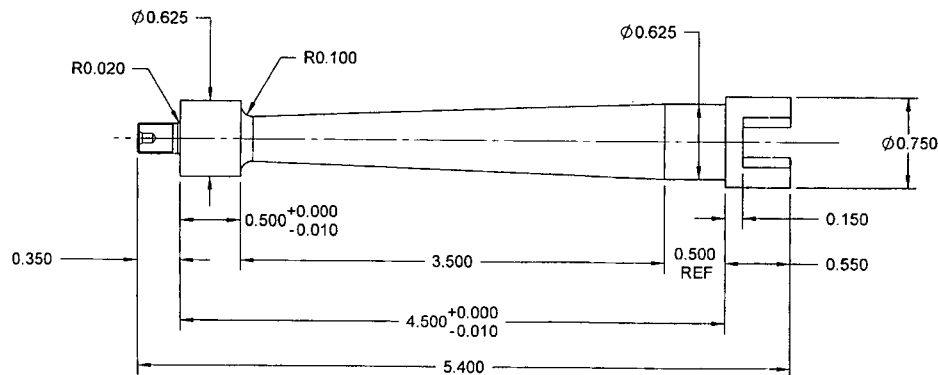
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NOTE: Date & initial all entries

0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
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